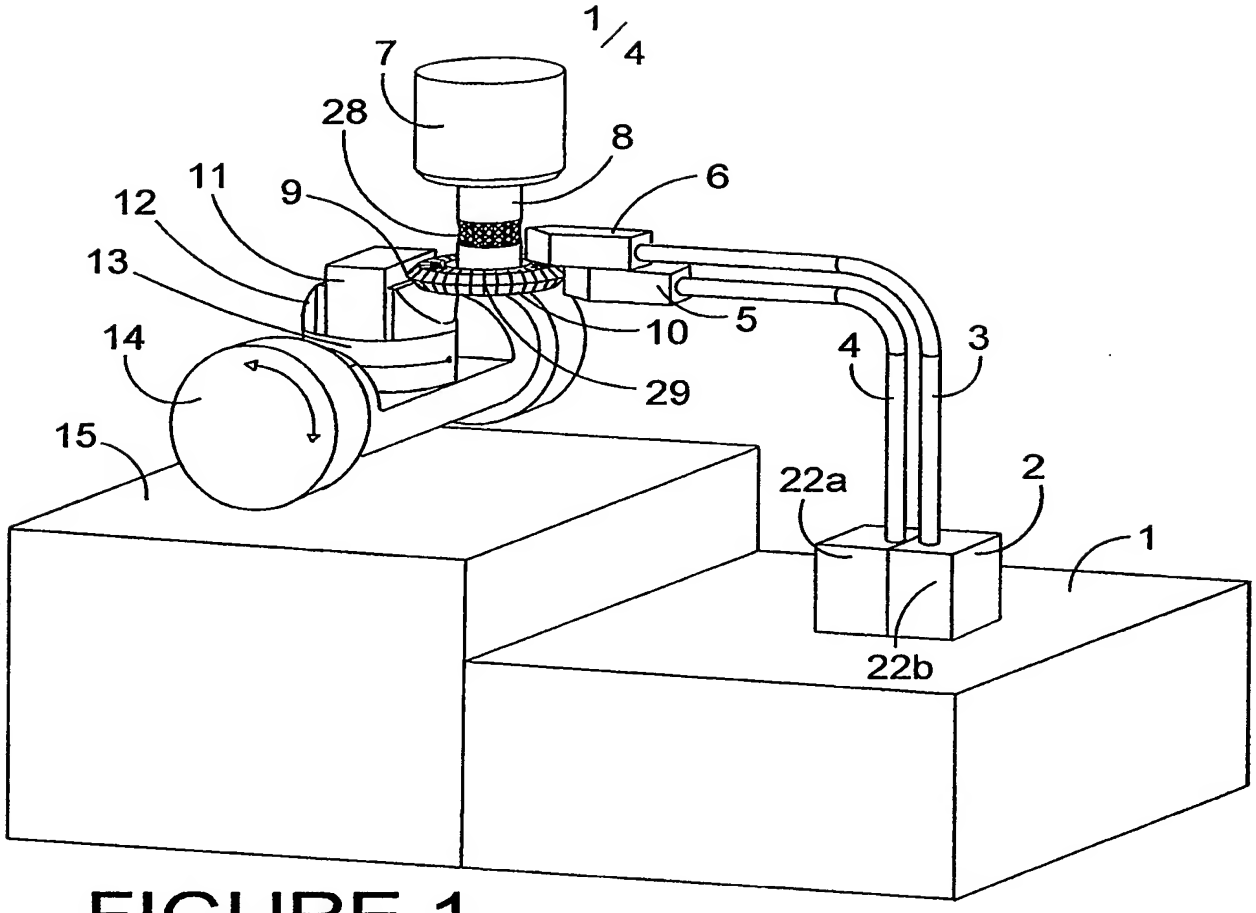

FIGURE 1

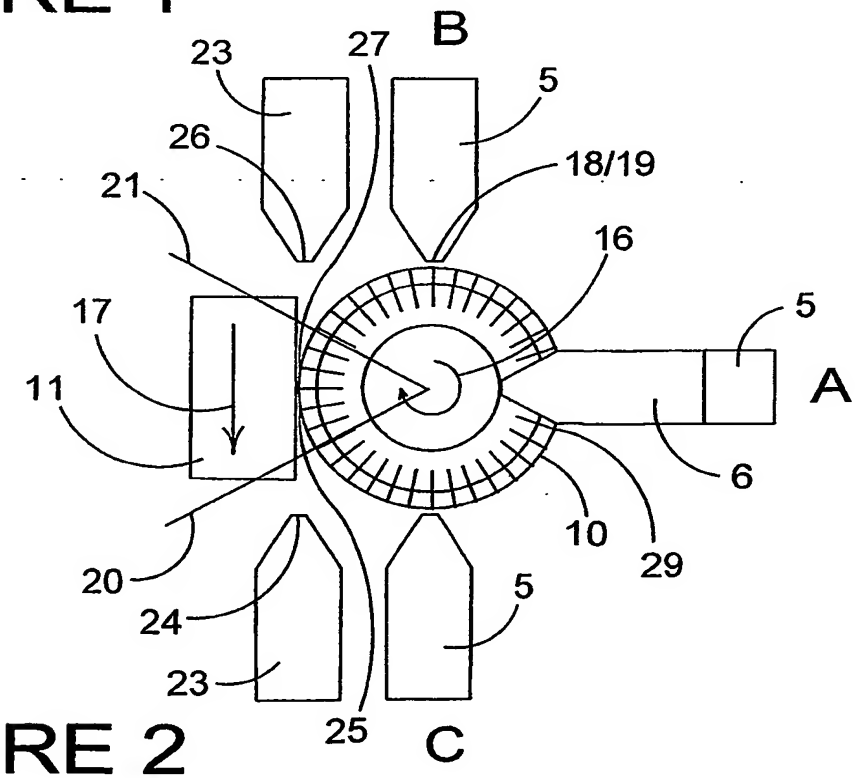

FIGURE 2

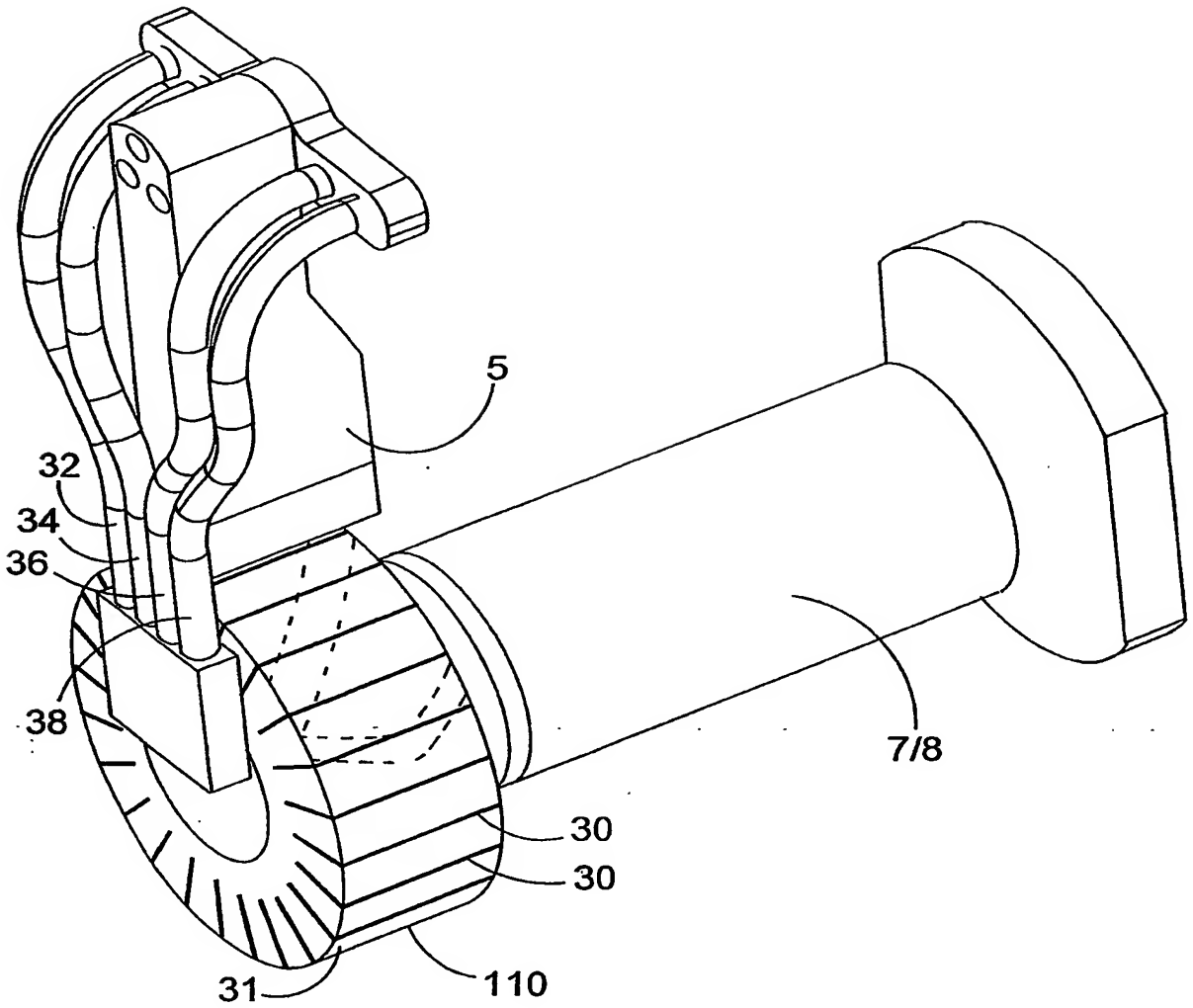

FIGURE 3

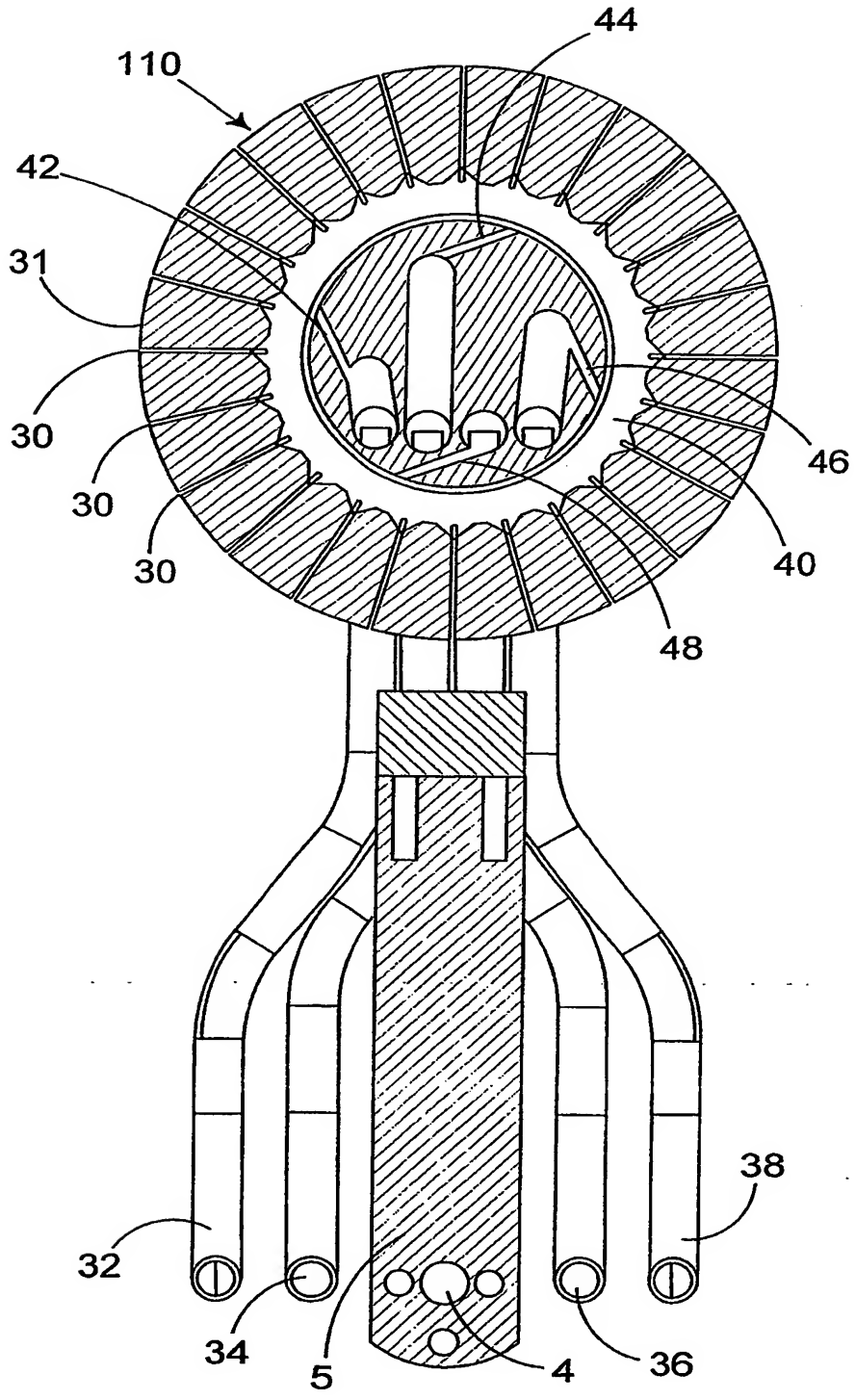

FIGURE 4

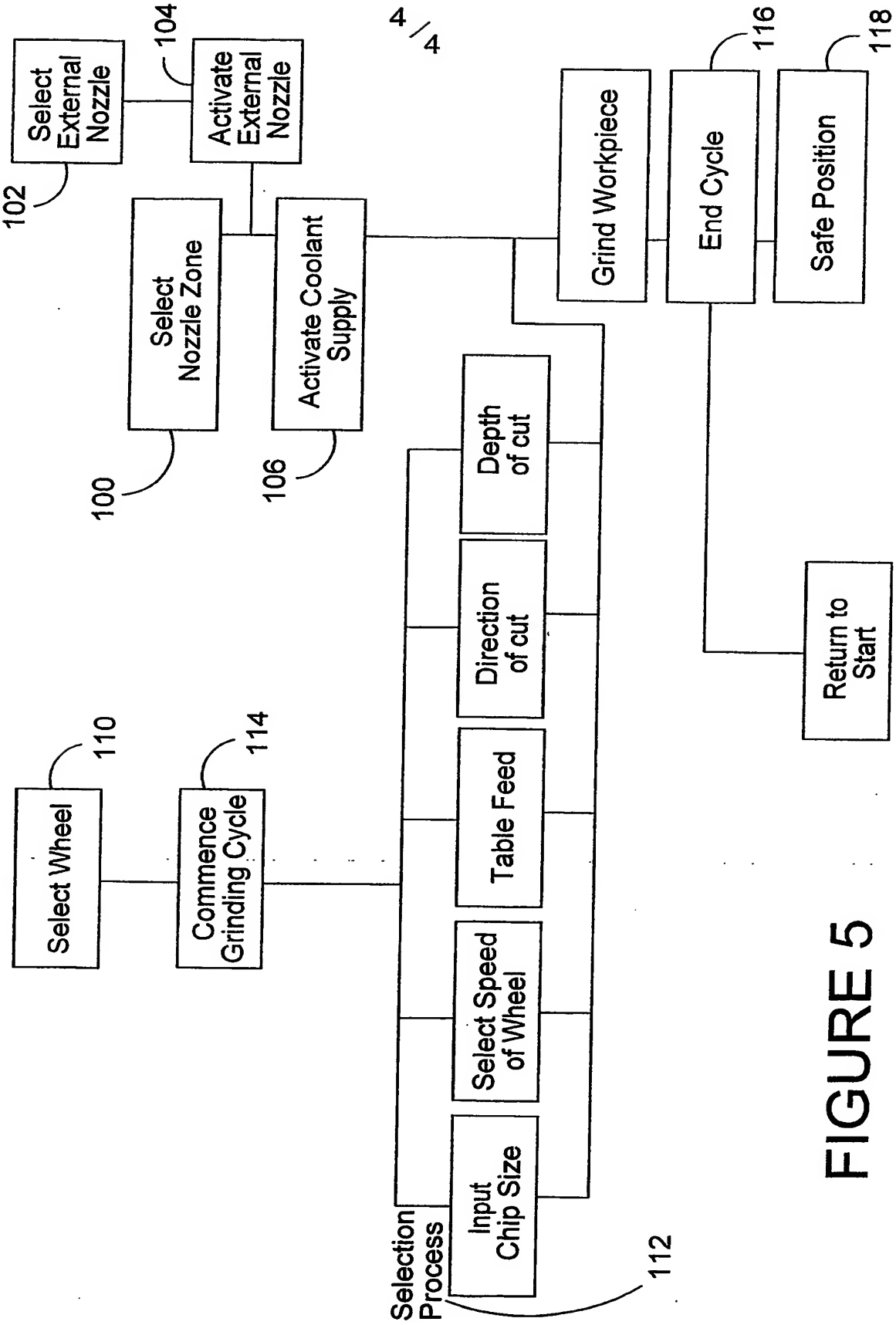
Select External Nozzle
102
Activate External Nozzle
104
Select Nozzle Zone
100
Activate Coolant Supply
106
Grind Workpiece
End Cycle
116
Safe Position
118
Depth of cut
Direction of cut
Table Feed
Select Speed of Wheel
Input Chip Size
Selection Process
112
Return to Start
Select Wheel
110
Commence Grinding Cycle
114

FIGURE 5